

JRH
3/19/92

JOB Contract 9010INSPECTION
REPORT # 4

These conditions were repaired. The assembly was checked by B&W's QA inspector, no other damaged was noted.

During an in-process inspection in the burner assembly area, one of the air zone damper (AZD) plates was noted to be severely warped. The plate was already installed in the burner. The plate was approximately 7/8" out of flatness. Production personnel indicated that this condition could be corrected by heat setting the plate. It was also noted that the spacer tabs mounted on the ID of the AZD assembly, to provide a 1/2" air gap, were off by as much as $\pm 1/8$ ". This condition was also brought to the attention of the production staff and was corrected.

The warped AZD plate was checked by the DWP QA engineer the following day and was found to be within tolerance.

During this visit, two trailers were loaded and ready for shipping, four clockwise and four counter clockwise. On two of the burners the shipping cradles under the air register assemblies were found not to be in full contact with the assemblies. The cradles had to be removed to correct the condition. Following the repair of the cradles, Load Nos. 5 and 6 were released for shipping and Mr. C. Finnigan at IPP was notified.

During the continuing in-process inspection by the DWP QA engineer parts awaiting assembly were checked. While spot checking various parts, additional spacer tabs in the AZD vane assemblies, the same ones mentioned above, were found to be out of tolerance. One of the AZD air sleeves was dimensionally checked and found to be out of round by over 1/2".

All of the above conditions were discussed with Mr. J. Taack, burner production manager, and Mr. J. Langley, burner and pulverizer QA supervisor. The DWP QA engineer expressed concern over the fact that defective parts were finding their way into the assembly area and into the burner assemblies themselves.

Mr. Taack said that he would motivate the assembly crews to be more aware of the parts they are assembling.

Mr. Langley said he would have his inspector increase his in-process inspections.

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As far as schedule is concerned, the work is about 1 1/2 weeks ahead. This was expected as additional work is scheduled to start in the shop the week of March 16, 1992, which may impact this contract and use up some of the cushion.

JEA:sl

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